

Work Order ID 66900

Wednesday, March 02, 2011 1:13:41 PM



Page 1

Item ID: D2576-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step (casting detail)

Start Date: 3/2/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 50.00



Customer:

-Reference:

Approvals:

Process Plan: CZ

Date: 11/03/02

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2576

Rev G

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 13586 ☐ Ship D2576 mould to vendor ☐ Cast per D2576-1
Pattern vendor: Alpine Non- Ferrous ☐ Material Release Note Required

CZ 11/03/02 (50)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure D2576 mould is returned with the ordered parts ☐ Ensure release note is attached

Pu/4/7 (54)

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

See 04/18'

countes
(x62)

Work Order ID 66900

Wednesday, March 02, 2011 1:13:41 PM



Page 2

Item ID: D2576-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step (casting detail)

Start Date: 3/2/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *MAT*

0.00

and 11/04/27

Packaging

Memo

0.00

*62**0*

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



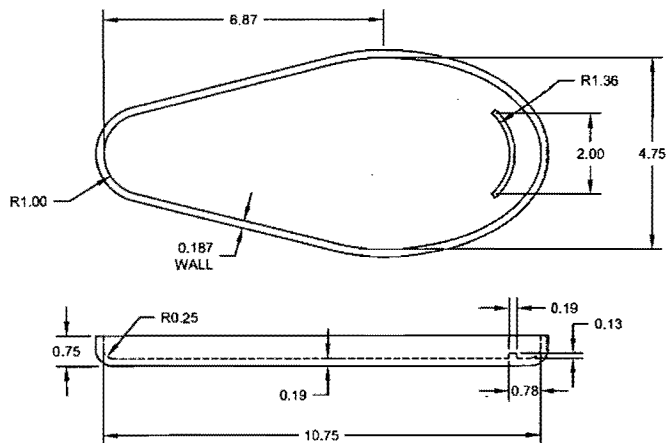
QC

Memo

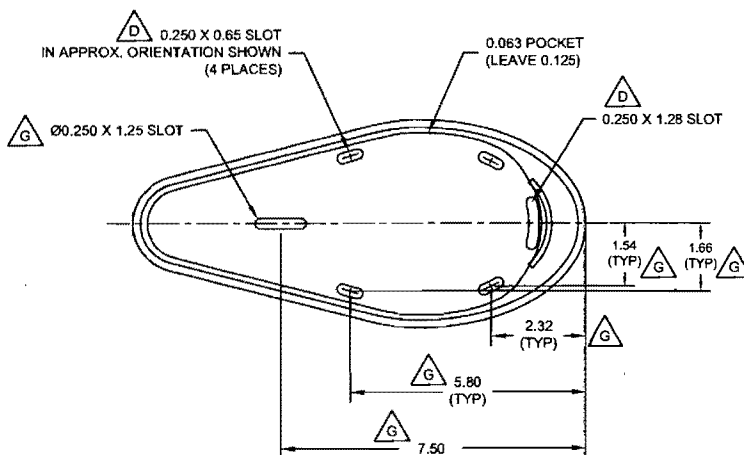
0.00

Quality Control

*11/4/27**MF**11-04-27*



D2576-1 CASTING



D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

C211103/02
W10' 66900

RELEASED

07.08.21

G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1089)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
REV.	DESCRIPTION	BY	DATE
DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	3		
CHECKED	PH		
MFG. APPR.	21		
APPROVED	11		
DE APPR.	11	DRAWING NO. D2576 REV. G SHEET 1 OF 1 TITLE SCALE 1:3	
DATE	07.08.15	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO13586

Purchase Order Date 3/2/2011

PO Print Date 3/3/2011

Page Number 1 of 1

Order From :

VC-ALP001

ALPINE NON-FERROUS FOUNDRY
8657 - 132ND STREET
SURREY, BC V3W 4P1
CA

Date Received

Contact Name

Vendor Phone 604 596 8080

Vendor Fax 604 596 8045

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

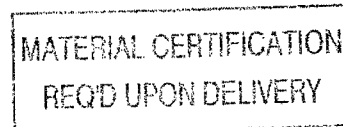
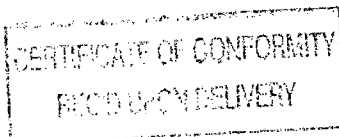
Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2576-1P	Step (Casting Detail)	4/8/2011 Yes	50.00 Each	FedEx PI collect	\$17.7500	\$887.50

Special Inst: AS PER DWG D2576 REV. G
B66900
ALPINE NON-FERROUS :
MATERIAL CAST ALUMINUM
ALLOY A-535.2

PO Total: \$887.50



W *cy*

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 3/3/2011

ALPINE NON-FERROUS FOUNDRY8657-132ND STREET
SURREY, B.C. V3W 4P1**WORK ORDER**

Tel: (604) 596-8080

Fax: (604) 596-8045

Sold To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA**Ship To:** DART AEROSPACE

Order Date		Purchase Order#	Due Date	Ship Via		Page
03-Mar-11		PO13586	08-Apr-11	FEDEX		1
Item#	Item Code	Description	Material	Ordered	B/O	Qty Ship
1 2	DART D2576	D2576 STEP CSTG <u>count 62 PCS.</u>		50		54

Comments

Castings&Patterns are property of Alpine until paid in full

BECK ALUMINUM LEBANON

Division of Beck Aluminum Alloys LTD

24 KEYSTONE DRIVE

LEBANON, PA 17042

Telephone: 717/277-0300

Fax: 717/277-0310

3130672

Ship Date 11/19/10

Sold To:

RYPAC ALUMINUM RECYCLING LTD.
11849 TANNERY RD.
SURREY, BC V3V 3W8
CANADA

Ship To:

RYPAC ALUMINUM RECYCLING LTD.
11849 TANNERY RD.
SURREY, BC V3V 3W8
CANADA

CHEMICAL ANALYSIS - ELEMENTS LESS THAN 0.01% MAY NOT BE REPORTED

Customer	Ship Via	F.O.B.										Terms			
RYPAL	CPU # 2142	LEBANON, PA										Net 30 Days			
Purchase Order Number										Salesperson	Order Date	Our Order Number			
2472										JM	11/18/10	326798			
Item Number / Item Description															
I535.2 - PRIMARY ALUMINUM INGOT															
Customer Item Code:															
Heat #	LBS	SI	FE	CU	MN	MG	CP	NI	ZN	TI	PB	SN	SF	BB	
X34306-001	2090	0.08	0.07	0.00	0.18	7.23	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0043	
X34306-002	1908	0.08	0.07	0.00	0.18	7.23	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0043	
X34306-003	2088	0.08	0.07	0.00	0.18	7.23	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0043	
X34306-004	2164	0.08	0.07	0.00	0.18	7.23	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0043	
X34306-005	2112	0.08	0.07	0.00	0.18	7.23	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0043	
X34306-006	1950	0.08	0.07	0.00	0.18	7.23	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0043	
X34306-007	2004	0.08	0.07	0.00	0.18	7.23	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0043	
X34306-008	1932	0.08	0.07	0.00	0.18	7.23	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0043	
X34306-009	2072	0.08	0.07	0.00	0.18	7.23	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0043	
X34306-010	2072	0.08	0.07	0.00	0.18	7.23	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0043	
X34306-011	1992	0.08	0.07	0.00	0.18	7.23	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0043	
X34306-012	1992	0.08	0.07	0.00	0.18	7.23	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0043	
X34306-013	2160	0.08	0.07	0.00	0.18	7.23	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0043	
X34307-071	1822	0.08	0.08	0.00	0.17	7.18	0.00	0.00	0.01	0.17	0.00	0.00	0.000	0.0045	
X34307-072	1930	0.08	0.08	0.00	0.17	7.18	0.00	0.00	0.01	0.17	0.00	0.00	0.000	0.0045	
X34307-073	1866	0.08	0.08	0.00	0.17	7.18	0.00	0.00	0.01	0.17	0.00	0.00	0.000	0.0045	
X34307-074	1886	0.08	0.08	0.00	0.17	7.18	0.00	0.00	0.01	0.17	0.00	0.00	0.000	0.0045	
X34307-075	1876	0.08	0.08	0.00	0.17	7.18	0.00	0.00	0.01	0.17	0.00	0.00	0.000	0.0045	
X34307-076	1870	0.08	0.08	0.00	0.17	7.18	0.00	0.00	0.01	0.17	0.00	0.00	0.000	0.0045	
X34307-077	1852	0.08	0.08	0.00	0.17	7.18	0.00	0.00	0.01	0.17	0.00	0.00	0.000	0.0045	
X34307-078	1932	0.08	0.08	0.00	0.17	7.18	0.00	0.00	0.01	0.17	0.00	0.00	0.000	0.0045	
X34307-079	1920	0.08	0.08	0.00	0.17	7.18	0.00	0.00	0.01	0.17	0.00	0.00	0.000	0.0045	
Weighted Avg.		0.080	0.074	0.000	0.176	7.211	0.000	0.000	0.004	0.182	0.000	0.000	0.000	0.004	

Special Requirements: INVOICE, PACKING LIST AND COA FAXED OR EMAILED ASAP.

Delivery Information: CPU, Van

Total 43490

CAUTION: INGOTS ARE SUBJECT TO THE FORMATION OF SHRINKAGE CAVITIES WHICH MAY ENTRAP MOISTURE. SUCH MOISTURE CAN CAUSE AN EXPLOSION HAZARD. TO MINIMIZE THIS HAZARD, ALL INGOTS MUST BE THOROUGHLY DRIED TO REMOVE ANY ENTRAPPED MOISTURE BEFORE CHARGING THEM INTO MOLTEN METAL

Authorized Signature

Date

**ALPINE NON-FERROUS FOUNDRY**8657-132nd Street,
Surrey, B.C. V3W 4P1

Tel: (604) 596-8080 Fax: (604) 596-8045

E-mail: gdhiman@telus.net**FAX COVER SHEET**

Company: DART	From: Svetq
Attn: Shantal	Date: Apr. 12, 2011
Fax Number: 613-632-1053	Phone Number: (604) 596-8080

☐ Urgent ☐ Reply ASAP ☐ Please comment ☐ Please review ☐ For your information

Total pages, including cover: 2**Comments:**

Dear Shantal,
The description for this alloy is
535.2 - Aluminum Alloy, without
any letter. The manufacturer uses letter I
for their own identification in the
computer system.

I send to you one more material
certificate for the same material from
different supplier to show it.

If you have any question please call

Svetq,
Office Manager

Trialco Inc.
900 E. 14th Street
Chicago Heights, Illinois
60411-3002

Certificate of Analysis

Alloy	535.2	Heat #	E1A2
-------	-------	--------	------

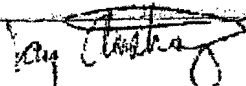
Bundle #
E1A2-040

Weight
1,878

Chemical Composition

Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Pb	Sn	Sr
0.05	0.08		0.18	7.41			0.03	0.17			
Ca	Na	Be	Bi	B	P	Cd	Sb	Zr			
		0.0040									

We certify that the above analysis is the result obtained in our laboratory for the heat indicated.



Jay Armstrong